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4.5NR-24
Job Sheet 196485



Part No: 4.5NR-24

Job Qty: 9 pcs

Part Name: Bumper2



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 6/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 4.5NR-24 Rev.1A IPP Rev. A 19.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	9 pcs	6/29/19	6/29/19	0.00	0.90	Small Fab - 1		AP 2019/06/13
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	9 pcs	6/29/19	6/29/19	0.00	0.00	QC 5 - 10		DAS JUN 26 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	Packaging 3-1 - Stock - B4B	9 pcs	6/29/19	6/29/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S193740



Part: 4.5NR-24

Job No: 196485

Serial No/Batch: S193740

Revision: 1A

Inspector:

Exp Date:

Instructions:

Date: 06/25/19

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Plex 6/13/19 11:45 AM Dart.lajeunesse.marie

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	9 pcs	6/29/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Small Fab - 1-Mix 80A liquid urethane using base and activator as per manufacturer instructions. A/R;
 Descriptions: M 5170556 EXP. 10/01/2019 2-Pour into appropriate mold. 3-Let cure as per manufacturer instructions.
 Time; 9.00 Date; 6/13/19 4-Remove from mold. 5-Chamfer ends as per DWG. 6-Deburr if required.
 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

DAS 70 9-89

JUN 28 2019

G210B

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
8644K12	80A Liquid Urethane	.0090 pcs (.001 ea)	100-Small Fab - 1	<u>S 170556</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	8644K12	0	2	0

Part Specifications	
Specifications could not be found.	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

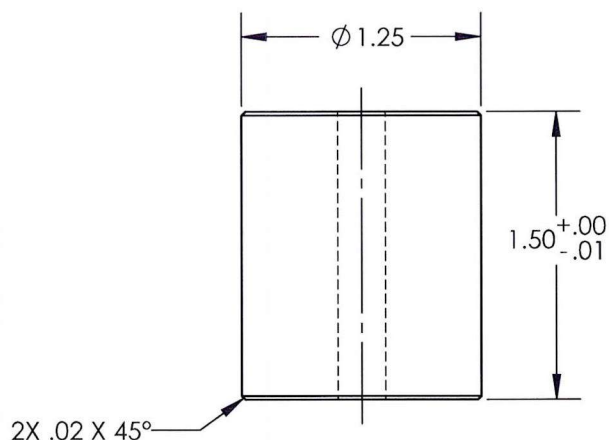
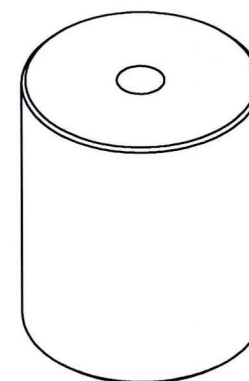
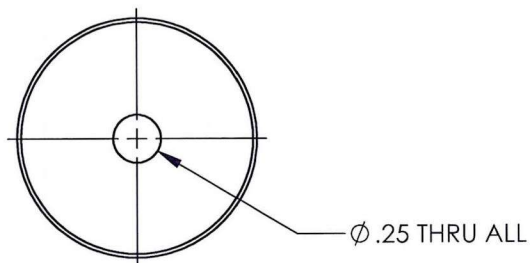
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM.	7/16/2013	JAG	
1A	14-0095	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE.	7/28/2014	DPD	RW



NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOAD STOP FRONT BUMPER	
DWG NO. 4.5NR-24	REV 1A
MAT'L URETHANE	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D West</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 10/21/1997 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			4.5NR-24	1	LOAD STOP FRONT BUMPER	URETHANE	Ø1-1/4 X 1-1/2